

Work Order ID 159884

Wednesday, April 19, 2017 12:11:17 PM

159884

Page 1

Item ID: D4008-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Filler Splash Guard Assembly
Start Date: 4/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-39 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4008	E								

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: EProg Rev: E

2-Deburr if necessary

0.40

(4)

04/17/05/03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.04

(4)

04/17/05/03

DAS
 38
 9-89
 MAY 05 2017

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MAY 09 2017

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Page 4

Accept

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

Start Date: 4/21/2017 **Start Qty:** 4.00

Required Date: 5/1/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED/S

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

0.00

160

2.28

SprayPaint

Memo

*****REMOVE PIN PRIOR TO PRIME AND PAINT AND KEEP IT IT WILL
NEED TO BE RE-INSTALL ON HINGE*****

1- PRIME TEMPO GREY (4.2.1.3.2) AS PER DWG
PRIMER BATCH: 136082

2- PAINT FLAT GREY (4.2.2.3) AS PER DWG
PAINT BATCH: 135260

170

QC14- Inspect Spray Paint

0.00

170

0.04

QC

Memo

Quality Control

159884

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

Start Date: 4/21/2017 **Start Qty:** 4.00

Required Date: 5/1/2017 **Req'd Qty:** 4.00

4

Customer:

Reference: SCHEDULED/S

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

180

1.08

Small Fab

Memo

Assemble as per dwg and re-install pin in hinge.

Small Fab

4x

Stamp
17/06/06
DAS
36
9-89

0.00

190

0.08

QC

Memo

Quality Control

i

DAS
38
9-89
JUN 06 2017

0.00

200

0.04

Packaging

Memo

Packaging

4x

26
9-89

JUN 07 2017

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Item ID: D4008-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Filler Splash Guard Assembly
Start Date: 4/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.40							
Quality Control									

JUN 07 2017

Picklist Print

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Work Order ID: 159884

159884

Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/21/2017

Required Date: 5/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07
AS PER DWG REV.C DD VERF:EC IPP REV:D 15.01.05 AS PER
DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	148.8536	0.2735	1.151579			

M6061T6S 032

6061-T6 Sheet 0.032"

12/17/05/03

Location	Loc Qty	Loc Code
MAT021	148.853563	
m131352	5.320037	
m135724	54.933526	
m136942	88.6	

MS20001-4

MS20001-4

Pin

DAS
30
9-89

Purchased

No

180

f

18.0000

1

4

Location	Loc Qty	Loc Code
ST479a	18	
M130922	6	
M132858	12	

D3941

D3941

Rubber Cushion (\$ per ft)

Manufactured

No

180

f

97.1163

0.21

0.884210

17/05/17 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	97.1163144	
133414	94.2810517	
48512	2.8352627	

0.884210

Picklist Print

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Work Order ID: 159884

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Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/21/2017

Required Date: 5/1/2017

Start Qty: 4.00

Required Qty: 4.00

D4008-5 Manufactured No

180 Each 7.0000 1 4

D4008-5

Fuel Filler Splash Guard Hinge Half

**

17/05/15 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

7

137339

2

154567

2

157635

3

2

159791 (u)

D4008-9 Manufactured No

180 Each 3.0000 1 4

D4008-9

Spring

**

17/05/17 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

3

122478

3

3

161513 (u)

D4008-7 Manufactured No

180 Each 25.0000 2 8

D4008-7

Washer

**

17/05/17 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

25

106676

3

137107

22

8

MS20470AD3-3 Purchased No

180 Each 6,032.000 5 20

MS20470AD3-3

RIVET, UNIVERSAL HEAD

**

17/05/15 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

787

1065

787

ST310

5245

16941

5245

20

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Shop Packet Print

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Picklist Print

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Work Order ID: 159884

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Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/21/2017

Required Date: 5/1/2017

Start Qty: 4.00

Required Qty: 4.00

MS21042L08

Purchased

No

180

Each

426.0000

2

8

MS21042L08

Nut

17/05/17
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

214

m135274

18

m135978

196

ST303

212

m137320

212

MS35206-S245

Purchased

No

180

Each

107.0000

2

8

MS35206-S245

Screw

17/05/17
DAS
36
9-89

Location

Loc Qty

Loc Code

ST271

107

m127432

107

NAS1149DN832J

Purchased

No

180

Each

752.0000

6

24

NAS1149DN832J

Washer

17/05/17
DAS
36
9-89

Location

Loc Qty

Loc Code

ST264

752

M135297

752

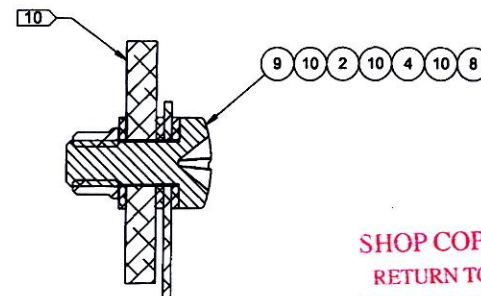
24

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Shop Packet Print

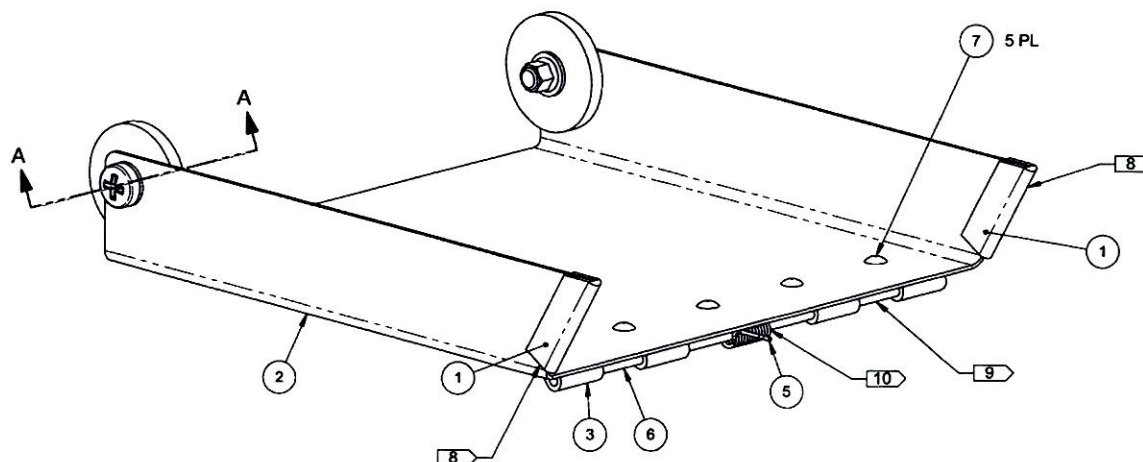
Page 3

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
1	2	D3941-1	RUBBER CUSHION	
2	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
3	1	D4008-5	HINGE HALF	
4	2	D4008-7	WASHER	
5	1	D4008-9	SPRING	
6	1	MS20001-4	PIN	
7	5	MS20470AD3-3	RIVET	
8	2	MS21042L08	NUT	
9	2	MS35206S245	SCREW	
10	6	NAS1149DN832J	WASHER	



SECTION A-A
SCALE 2X
2 PL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159884 MJS
17-04-19



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SIKAFLEX ADHESIVE, TRIM TO FIT, AFTER PRIME AND PAINT
- 9) MASK HINGE PIN AREA BEFORE PRIME AND PAINT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER PRIME AND PAINT

E	REVISED FINISH ON SHT 1 & 5; REDRAW SECTION A-A SHT 1; RE-ORGANIZED ITEM NUMBERS (SHT 1 & 2); ADDED MISSING DIMS ON D4008-5; MS21059L3 WAS MS21059L4 (SHT 2); INCREASED VIEW SIZES ON SHT 2, 3, 5; ADDED NOTE 8 (SHT 5); REMOVED DIMPLING NOTE FROM SHT 6	AP	14.12.05
D	ADDED RIVET HOLES TO D4008-11 (C7-10) UPDATED NOTES ON ALL SHEETS	ML	14.05.13
C	CHANGE POWDER COAT FROM "GREY SANDEXT" TO "ANSI 61 GREY"; CORRECT MATERIAL ERROR, ZN A7-6. ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4008 SHEET 1 OF 10 TITLE SPLASH GUARD SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AP		
CHECKED	DB		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS	DATE 14.12.05	

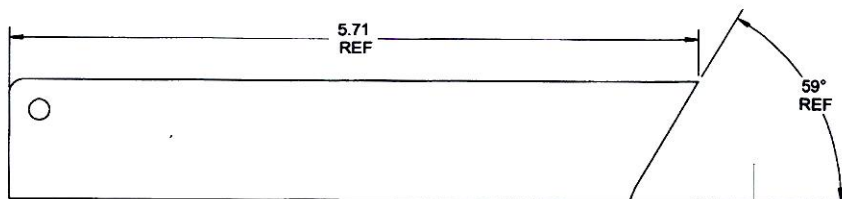
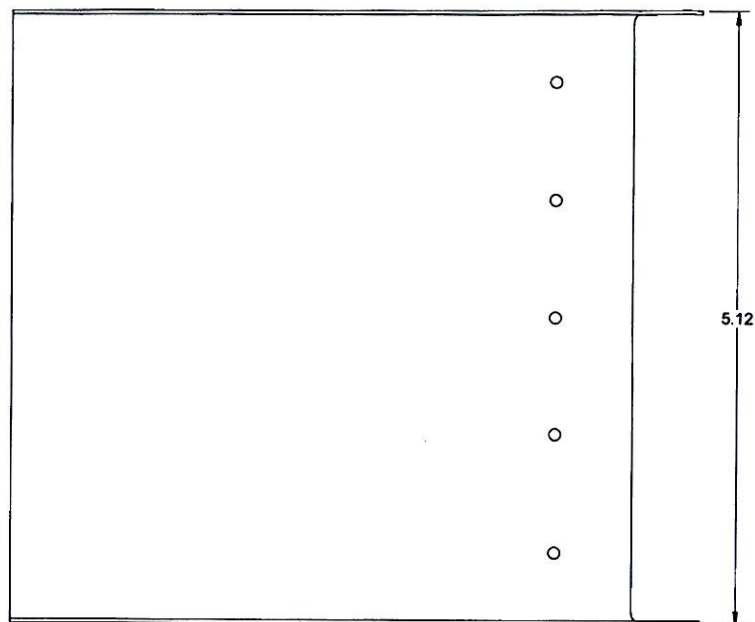
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RELEASED

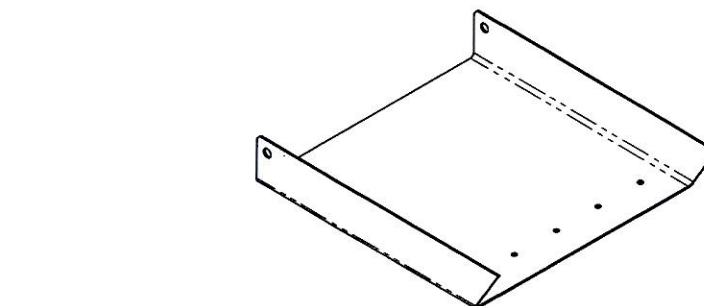
2015 JAN 15

ECN 14-666

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-1	REF JCA-M47-2-26



D4008-1 FUEL FILLER SPLASH GUARD CHANNEL
(MAKE FROM D4008-1F)



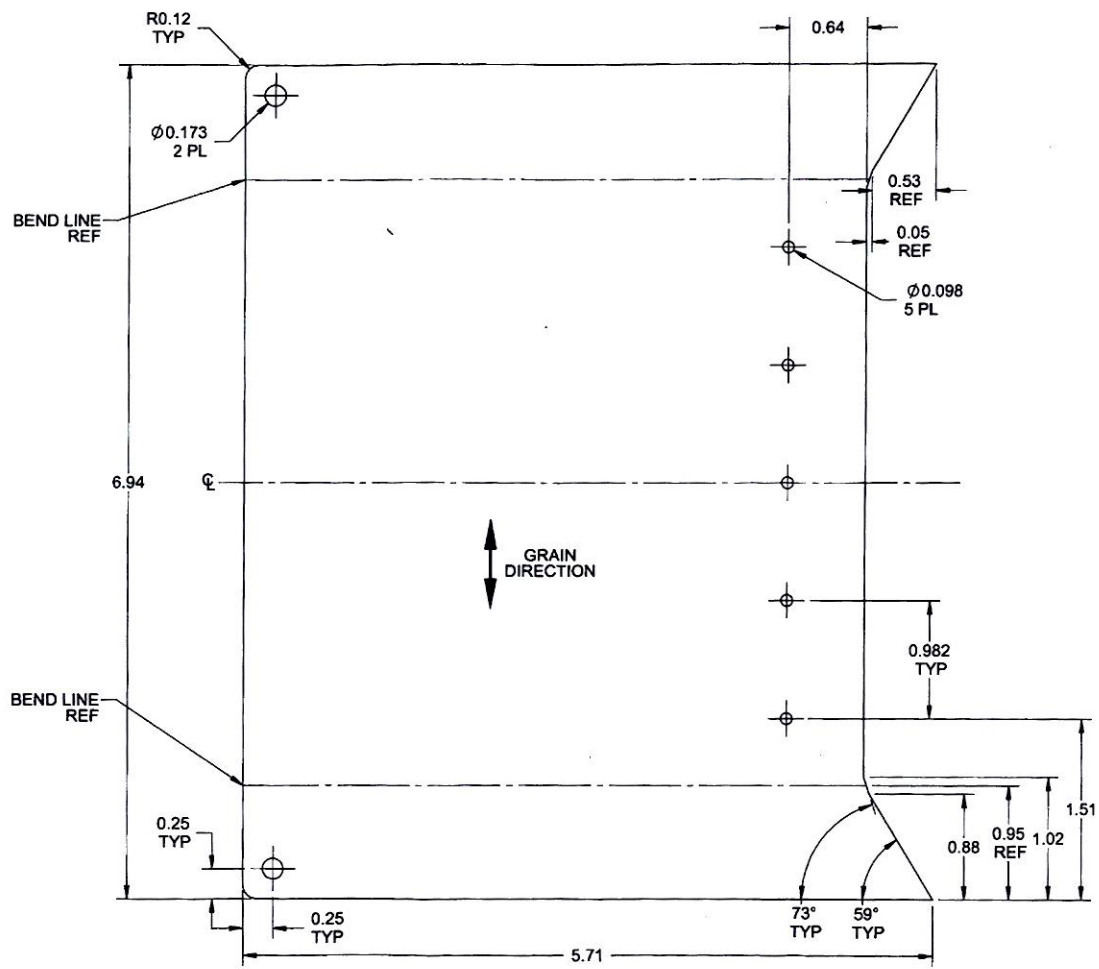
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2015 JAN 15 *ap*

- NOTES:
- 1) MATERIAL: MADE FROM D4008-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	DB	DRAWING NO.	REV. E
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D4008-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

RELEASED

2015 JAN 15

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